



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2571
Job Sheet 200381



Part No: D2571

Job Qty: 10 pcs

Part Name: Saddle, Fwd, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/10/19

Job Tracking No:

Due Date: 10/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	10 pcs	10/8/19		0.00	0.00	HAAS - 1		SBL P/10/23
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
100	HAAS 4 Axis - B4B	10 pcs	10/8/19		1.00	16.13	HAAS - 1 - B4B		SBL 19/10/28
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
110	Conventional Mill - 1 - B4B	10 pcs	10/8/19		0.00	1.54	Conventional Mill - 1 - B4B		SBL 19/10/28
							Conventional Mill - 2 - B4B		
120	QC 2	10 pcs	10/8/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		



Container No: S225354



Part: D2571

Job No: 200381

Serial No/Batch: S225354

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/22/19

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					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	SBC 19/10/25
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
QC 8 - 32						
QC 8 - 33						
QC 8 - 35						
QC 8 - 39						
QC 8 - 4						
QC 8 - 44						
QC 8 - 45						
QC 8 - 49	marc 19/11/02					
QC 8 - 58						
QC 8 - 8						
QC 8 - 9						
QC 8 - 68						
QC 8 - 67						
QC 8 - 1 (A)						
QC 8 - 47						
QC 8 - 40						
QC 8 - 52						
QC 8 - 23						
QC 8 - 57						
QC 8 - 76						
140 Handfinish - 1-1 Chemical-B4B	10 pcs	10/8/19	0.00	0.33	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	NOV 04 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 -	

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[illegible]

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	10 pcs	10/8/19	0.00 0.00	QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	NOV 19 2019
				QC 21 - SA - 53	

Part Op 100 - (HAAS CNC vertical machine #1) Program Batch No 5205354 Double check by: SL 1-Machine Step No 1
 Descriptions: per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per
 attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect
 110 - (Manufacture as per dwg) Machine keyway as per dwg D2571 & D2572
 120 - (QC2- Inspect parts off machine FA/FAIB) Inspect on CMM as per folio CMM022.
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	10 pcs (1 ea)	90-Machining - Issue SN	5196109

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-007	10	41	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Outboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Fwd Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Fwd Outboard	7.990Inches + 0.020 - 0.000	8.010 7.990		
6	Saddle, Fwd Outboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
7	Saddle, Fwd Outboard	0.257Inches + 0.005 - 0.000	0.262 0.257		
8	Saddle, Fwd Outboard	0.375Inches + 0.005 - 0.000	0.380 0.375		
9	Saddle, Fwd Outboard	0.490Inches + 0.020 - 0.000	0.510 0.490		

10	Saddle, Fwd Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Fwd Outboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Fwd Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Fwd Outboard	1.490Inches	+ 0.010 - 0.000	1.500 1.490
14	Saddle, Fwd Outboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Fwd Outboard	3.869Inches	+ 0.010 - 0.000	3.879 3.869
16	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Outboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308
25	Saddle, Fwd Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Outboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Outboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Fwd Outboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

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DART AEROSPACE LTD	Work Order: 200381
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.998	7.998	7.998		
F	0.490	0.510		.502	.500	.501	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.497	.499	.500	.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.571	.566	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.133	.135	.130	.132		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.250	.250	.250	.248		
S	0.115	0.135		.131	.127	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.96	2.960	2.960		
V	0.230	0.250		.240	.235	.238	.238		
W	0.115	0.135		.127	.118	.125	.125		
X	0.308	0.313		.308	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.363	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.624	.625	.624		
AC	0.053	0.073		.063	.073	.054	.064		
AD	0.240	0.260		.249	.244	.248	.247		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.125	.135	.120	.128		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.253	.244	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: SBL / VHS	Audited by: GMM/L
Date: 19/10/24	Date: 19/11/02

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 200381
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	17	18		
A	0.438	0.443		438	438	438	438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.998	7.997	7.997		
F	0.490	0.510		501	500	502	504		
G	0.257	0.262		257	257	257	257		
H	0.375	0.380		375	375	375	375		
I	0.490	0.510		497	500	500	498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		565	568	567	566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		128	129	133	134		
Q	0.115	0.135		125	125	125	125		
R	0.240	0.260		248	247	248	248		
S	0.115	0.135		128	129	130	130		
T	0.178	0.198		188	188	188	188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		239	239	238	238		
W	0.115	0.135		126	125	126	126		
X	0.308	0.313		312	312	312	312		
Y	0.760	0.765		760	760	760	760		
Z	0.352	0.372		363	363	363	364		
AA	0.470	0.530		500	500	500	500		
AB	0.615	0.635		624	624	625	624		
AC	0.053	0.073		0.65	0.61	0.64	0.63		
AD	0.240	0.260		249	248	247	247		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		135	133	133	133		
AG	0.240	0.280		265	260	260	260		
AH	0.240	0.260		252	252	252	254		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.33	0.33	0.33	0.33		

Accept/Reject

Measured by: SBL
Date: 19/10/07

Audited by: MML
Date: 19/11/02

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 200381
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	#9	#10	X	X		
A	0.438	0.443		.438	.438				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		7.998	7.998				
F	0.490	0.510		.503	.503				
G	0.257	0.262		.257	.257				
H	0.375	0.380		.375	.375				
I	0.490	0.510		.498	.498				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.567	.568				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.133	.135				
Q	0.115	0.135		.125	.125				
R	0.240	0.260		.248	.249				
S	0.115	0.135		.129	.129				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		.237	.238				
W	0.115	0.135		.125	.126				
X	0.308	0.313		.312	.312				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.364	.363				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.624	.624				
AC	0.053	0.073		.065	.063				
AD	0.240	0.260		.247	.247				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		.132	.133				
AG	0.240	0.280		.260	.263				
AH	0.240	0.260		.252	.252				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: SBL
Date: 14/10/28

Audited by: [Signature]
Date: 19/11/02

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	[Signature]



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐
Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐
Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐
Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐	

Other/Details: _____